

**IN THE SPECIFICATION:**

Please amend paragraph [0008] as follows:

Also, ~~[[since]]~~ because the bar member feeding device is provided separately from the vertical machining center and is arranged in the horizontal direction, the bar member feeding device is projected ~~remarkably~~ considerably in plan view outwardly from a body of the vertical machining center. For this reason, a space in plan view which is required to arrange the overall vertical machining center including the bar member feeding device is expanded.

Please amend paragraph [0011] as follows:

There is provided a five-axis controlling vertical machining center in which an axis of a main spindle rotatably supported by a spindle head is directed in a substantially vertical direction to a floor surface, a table, having a chuck, ~~is able to direct~~ adaptable to be directed upwardly, ~~the table being and positioned and is~~ disposed below a level of the spindle head, the spindle head is movable in three mutually transverse axes directions relative to a workpiece gripped by the chuck, and the table is driven to be swingable and to be also at least rotatable by a table drive unit, the vertical machining center comprising: a vertical stocker, which is disposed in the vicinity of the table, for stocking at least one bar workpiece in a vertical direction; and the spindle head provided with a hand portion which grips and releases the bar workpiece, wherein the spindle head moves between the table and a receiving and discharging position of the stocker so that the hand portion transfers the bar workpiece and performs putting and removing the bar

workpiece to the stocker and the chuck of the table, respectively.

Please amend paragraph [0039] as follows:

A hand portion 10 which may grip and release the bar workpiece 2 and which approaches the bar workpiece only in a horizontal direction is provided on the spindle head 5. The spindle head 5 moves between the stocker 7 and the table 6 so that the hand portion 10 transfers the bar workpiece 2. Also, the hand portion 10 performs putting and removing the bar workpiece 2 to the stocker 7 and the chuck 11 of the table 6, respectively.